

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029502**Date Inspected:** 05-May-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** N/A**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

Caltrans Quality Assurance Inspector (QA) Joe Adame was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

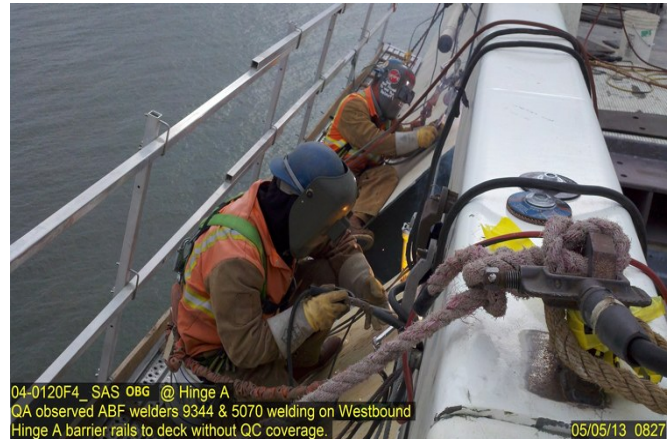
The QA Inspector randomly observed ABF welders Lin E Yun (WID#-9344) & Earl Clayborn (WID#-5070) performing Shielded Metal Arc Welding (SMAW) on West approach barrier rails to OBG at Hinge A (North side). The welders were observed preheating the welds prior to welding with a gas torches. The QA Inspector inquired with the welders if ABF QC had verified the welding parameters prior to commencing the work. The welders had stated that QC was not present at the start of welding and were instructed by ABF personnel to perform the work and in the absence of QC. The welders were observed performing SMAW 2G welding utilizing WPS ABF-D1.5-SMAW-1072. The welding parameters as observed by the QA Inspector appeared to be in compliance with the Welding Procedure Specification (WPS) noted above.

The QA Inspector randomly observed ABF welder Guo Wu Chen (WID#-1556) performing SMAW on the East approach barrier rails to OBG at Hinge A (South side). The QA Inspector also inquired with Mr. Chen if ABF QC had been monitoring the welding parameters prior to commencing the work. Mr. Chen also replied that QC was not present. The welder was observed preheating the welds prior to welding with a gas torch and verifying heat with a temperature indicator. The welder was also observed performing SMAW 2G welding utilizing WPS ABF-D1.5-SMAW-1072. The welding parameters as observed by the QA Inspector appeared to be in compliance with the WPS noted above. The work continued through-out the shift and the barrier rails welds are still in process.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

*On this date, the QA Inspector did not observe ABF Quality Control Inspectors present to monitor the welding operations of the contractor as required by contract. Per section 8-3.1 of the Special Provisions-“QC inspections shall be provided to ensure continuous inspection when any welding is being performed”. The QA Inspector notified QA Lead Inspector Scott Croft of the welding in non-compliance on the barrier rails. Mr. Croft informed ABF Welding QC Manager Jim Bowers and SMR Bahjat Dagher of the issue. The QA Inspector was requested by Mr. Dagher to monitor the welding on this shift to ensure that no additional issues may arise on the shift. Please see TL-15 (Incident Report) for additional information on the welding in non-compliance observed on this date.



Summary of Conversations:

Only general conversations with ABF personnel relevant to work performed during this shift.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

Inspected By:	Adame,Joe	Quality Assurance Inspector
Reviewed By:	Reyes,Danny	QA Reviewer
